

17/09

Date: Tuesday, 9/11/2007 10:56:12 AM
User: Chantal Lavoie









Process Sheet

Customer :
Job Number : 34542
Estimate Number : 12961
P.O. Number : N/A
This Issue : 9/11/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL /MED FAB
Previous Run : 33722
Drawing Name : COVER
Part Number : D36411
Drawing Number : D3641 UNDER REVIEW
Project Number : N/A
Drawing Revision : U/R
Material : N/A
Due Date : 9/18/2007 Qty: 12 Um: Each
Written By :
Checked & Approved By :
Comment : Est Rev: New Issue 07-07-20 JLM Verified By: EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S032 -	6061-T6 Sheet 0.032"
Comment: Qty.: 0.8244 sf(s)/Unit Total : 9.8923 sf(s) M6061-T6 .032" THK sheet Batch: M 16954 HB 07-09-12		 
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3641 Dwg Rev: U/R Prog Rev: U/R HB 07-09-12 2-Deburr if necessary		 
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 07-09-12		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK Er 10/09/12 (12)		 
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Form as per Dwg D3641-1		 SP 07/09/13 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/10/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-09-12	S.O	120° ANGLE NOT ACHIEVED 2.50 IS 2.67	LE 07.09.12	ACCEPTABLE PART WILL FUNCTION IN SERVICE AS INTENDED. NOT A STRUCTURAL PART.	LE 07.09.12	En 07/09/13	LE 07.09.12 QS1042	En 07/09/13

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:56:12 AM
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Process Sheet

Customer:

Drawing Name: COVER

Job Number: 34542

Part Number: D36411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



center

Comment: INSPECT WORK TO CURRENT STEP

Er 07/09/13

(+12)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(12)

Comment: HAND FINISHING RESOURCE #1

BR 07-09-14

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

~~07-09-14~~

Er 07/09/14 (+12)

(+12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



POSITIVE
RECALL

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

7/10/15 SD 18X

ENGINEERING
APPROVAL
UE 07-09-14

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

UE 07/10/10

Job Completion



POSITIVE RECALL

EFFECTIVE 07/09/13 AUTH UE

RELEASED UE DATE 07-10-15

UE

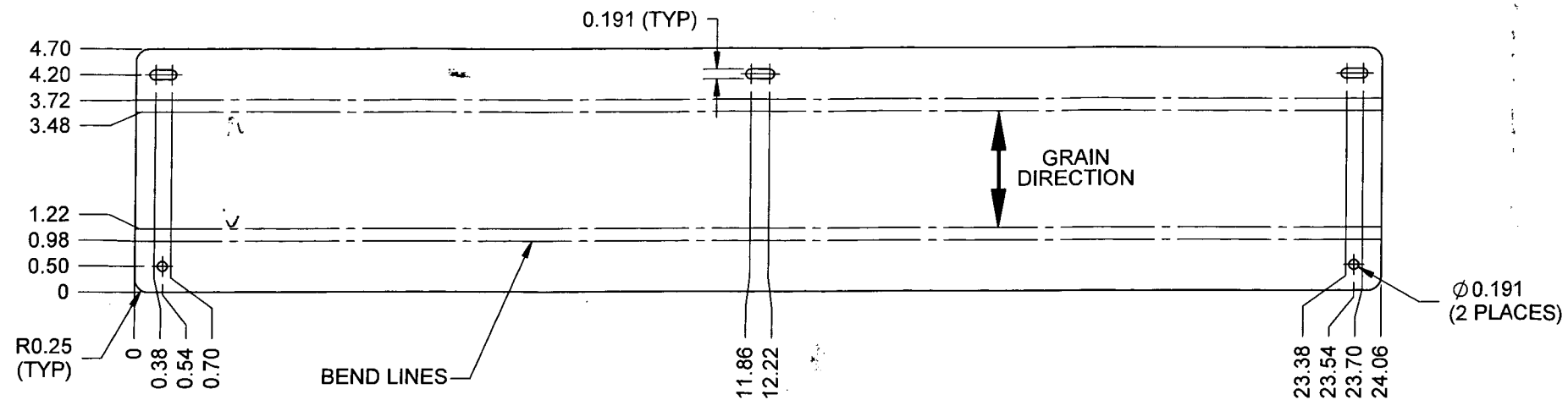
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

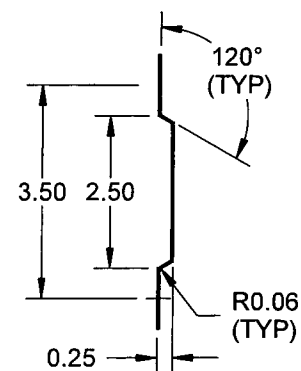
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3641-1F FLAT PATTERN



**D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)**

PRELIMINARY ISSUE

07-09-07

NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.032 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.35 lbs

A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	LET		
CHECKED	ET	DRAWING NO.	REV. A
MFG. APPR.	ET	D3641	SHEET 1 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.		COVER	1:3
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

